

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027317**Date Inspected:** 10-Mar-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**CWI Name:** Steve Jensen, Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) 12W/13W & 13W/14W - Longitudinal Stiffener Bottom Flange (LSBF) welding
- 2) West Span Deck Access Hole (DAH) welding

1) The QAI observed ABF personnel making partial joint penetration (PJP) welds at longitudinal stiffeners' bottom flanges at 12W/13W and 13W/14W. The QAI noted that ABF welder Jeremy Dolman, ID 5042, is working on stiffener #4 in 12W/13W field splice and ABF welder Richard Garcia, ID 5892, is working on stiffener #4 in 13W/14W field splice. The QAI noted that the Quality Control Inspector (QCI) Salvador Merino is monitoring this welding. At the start of shift, the QAI noted that the welds had previously been fit up. At both weld locations, the QAI verified that the preheat temperature was conforming to the welding procedure specification (WPS) ABF-WPS-D15-1162-4. As the welding progressed, the QCI informed the QAI that the welding parameters were conforming to the WPS. During this shift, the QAI made random observations of the work in progress at both locations and noted that the overhead groove (4G) shielded metal arc welding (SMAW) appeared to be conforming to the WPS requirements. The QAI noted that fill passes were being made and fit up attachments were being removed as the welding progressed. The QAI noted that at the end of shift, the work was not completed at either location. See the attached photo.

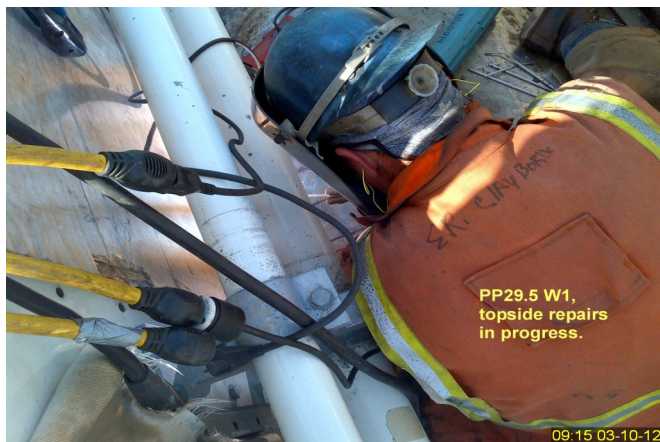
- 2) The QAI observed ABF welder Mike Jiminez making a complete joint penetration (CJP) weld at DAH at PP84.

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5 line W1. The QAI noted that the QCI Steve Jensen is monitoring the SMAW back welding of the oval shaped perimeter weld for the DAH. The QCI informed the QAI that ABF-WPS-D15-1110 rev.1 is being utilized for this work. The QAI was also informed that the longitudinal stiffener will not be welded until the DAH perimeter weld is accepted, as repairs may interfere with stiffener welds. The QAI made random observations of the work at this location and noted that throughout the shift, the 4G SMAW welding parameters were measured within the ranges listed on the WPS.

The QAI also observed ABF welder Rick Clayborn, ID 2773, making repairs to the CJP DAH at PP29.5 line W1. The QAI noted that the repairs are being performed from the top side, horizontal groove (2G) and bottom, 4G. The QAI noted that the QCI Steve Jensen is monitoring these SMAW repairs. The QAI was informed that the repairs will be examined on Monday, March 12th. The QCI informed the QAI that ABF-WPS-D15-1010A rev.1 is being utilized for the repairs. The QAI noted that the repairs were completed on the DAH perimeter weld. See the attached photo.



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the general observations and status of work to the QAI Lead Bill Levell and the QAI Danny Reyes. Except as described above, there were no other notable conversations or observations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
